

Work Order ID 73471



Page 1

Thursday, September 01, 2011 7:37:39 AM

Item ID: D3137-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Guide					
Start Date: 8/31/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 9/16/2011	Req'd Qty: 12.00		Customer:		

Reference:

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/09/10</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3137	Rev F								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blanks.Blank size: 1.250" x .750" x .950" long								

11/09/15

12 0

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA242 & Dwg D3137-2-Deburr								

11.9.15

12 0

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

11.9.15

12 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73471

Thursday, September 01, 2011 7:37:39 AM



Page 2

Item ID: D3137-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 8/31/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

B.A 11/09/16



QC Memo

0.00

Quality Control

12 0

140 Identify as per dwg & Stock Location 23SB

0.00



Packaging Memo

0.00

Packaging

11/9/19 12

150 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/9/19

MF 11-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 7:37:37 AM

Page 1

Work Order ID: 73471



Parent Item: D3137-3



Parent Item Name: Guide

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A 02.05.29 New Issue NG

IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC

IPP Rev c 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB0.75X1.250		Purchased		No		100	f	12.4948	0.0791	0.999158			



Delrin Bar

Location	Loc Qty	Loc Code
MAT055	12.4948	
117985	4.0948	
→ 118066	8	
14535	0.4	

1.00 *enl 11/09/15*

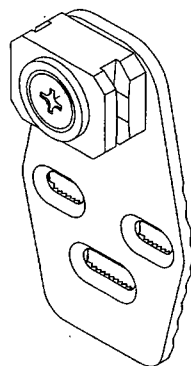
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

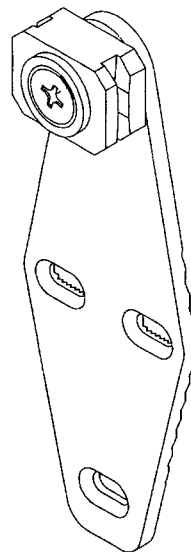
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

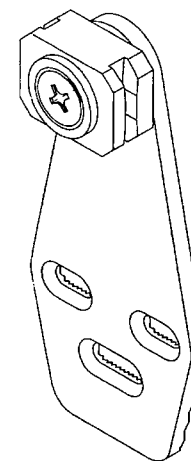
NOTE: Date & initial all entries



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



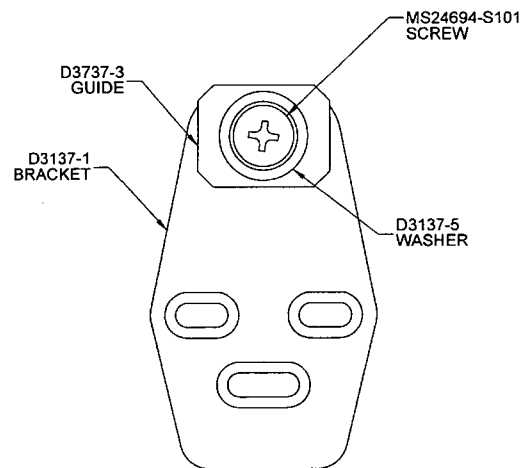
D3137-045 BRACKET ASSEMBLY

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08.05.30

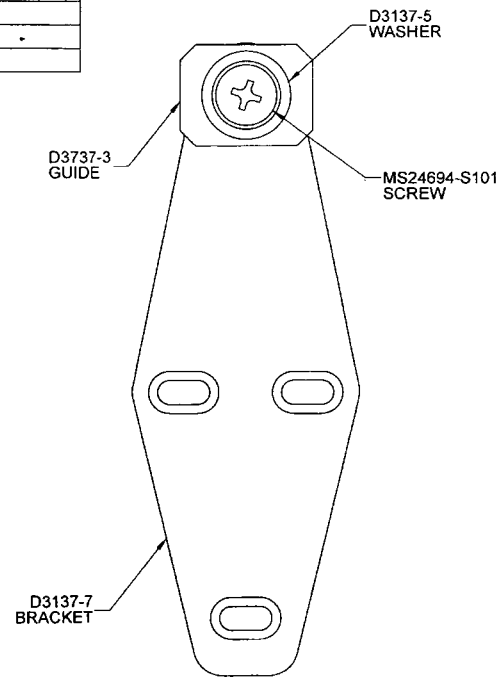
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
73571
08/11/09/101

REV.	F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A 5 DIM 2.36 WAS 2.48, ZONE A 4 0.480 DIM WAS 0.605, ZONE A 3 0.67 DIM WAS 0.79, ZONE B 5 4.850 DIM WAS 4.975 & ZONE B 8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
	E	ADD -045	RF	05.11.23
	D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
	C	ADD -043	DS	03.08.15
	B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
REV.	A	NEW ISSUE	DS	02.04.17
	DESCRIPTION		BY	DATE
DESIGN	DS		DART AEROSPACE LTD	
DRAWN	AJS		HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]		DRAWING NO.	REV. F
MFG. APPR.	[Signature]		D3137	SHEET 1 OF 5
APPROVED	[Signature]		TITLE	SCALE
DE APPR.	[Signature]		BRACKET ASSEMBLY	NTS
DATE	08.05.30		COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

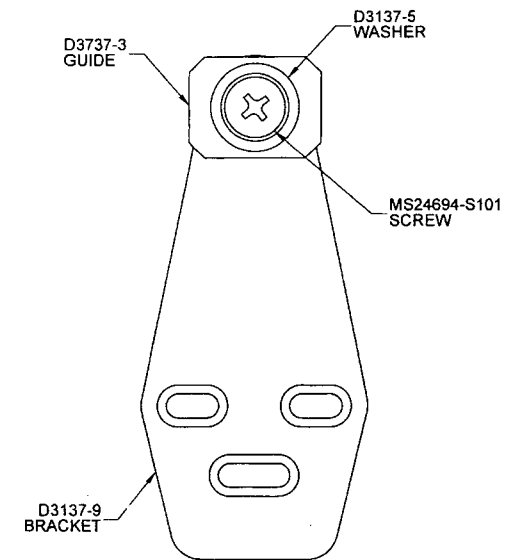
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY






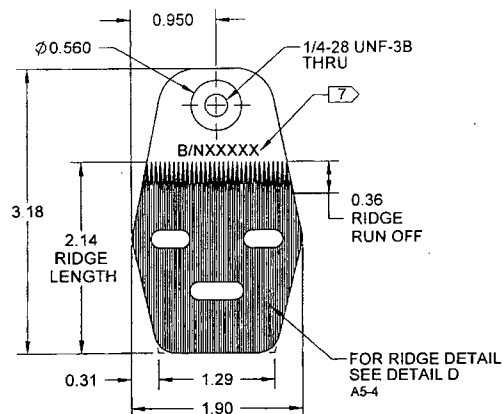
D3137-045 BRACKET ASSEMBLY

NOTES:

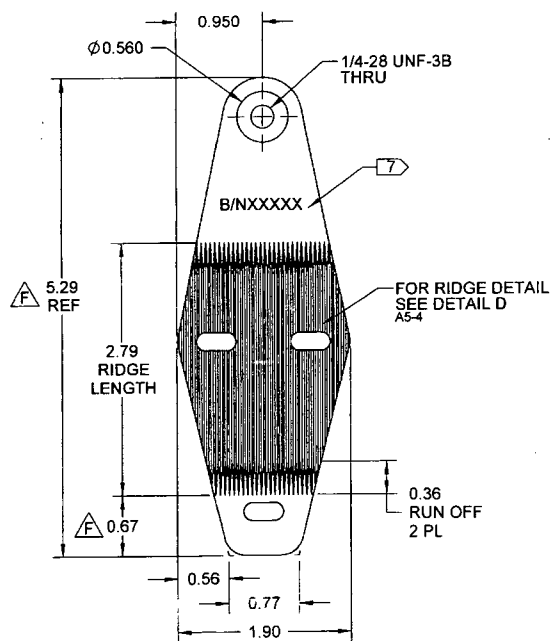
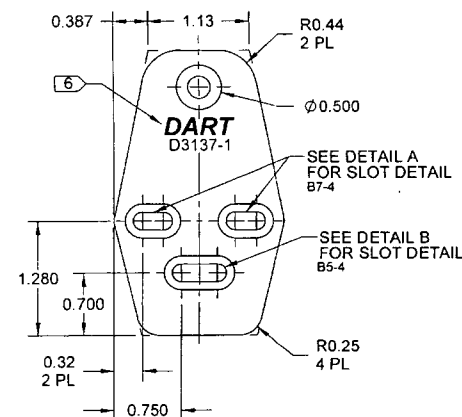
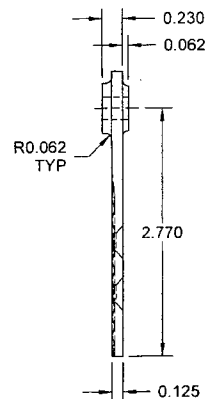
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
: 0.32 lbs -043
: 0.27 lbs -045

RELEASED
28.06.26.18

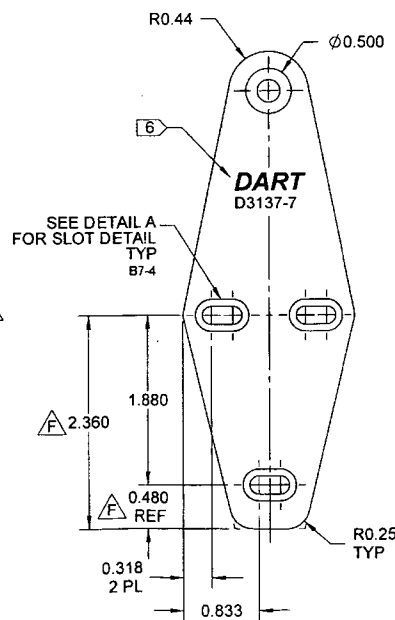
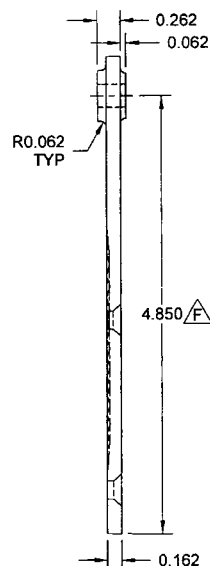
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DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
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D3137-1 BRACKET



D3137-7 BRACKET

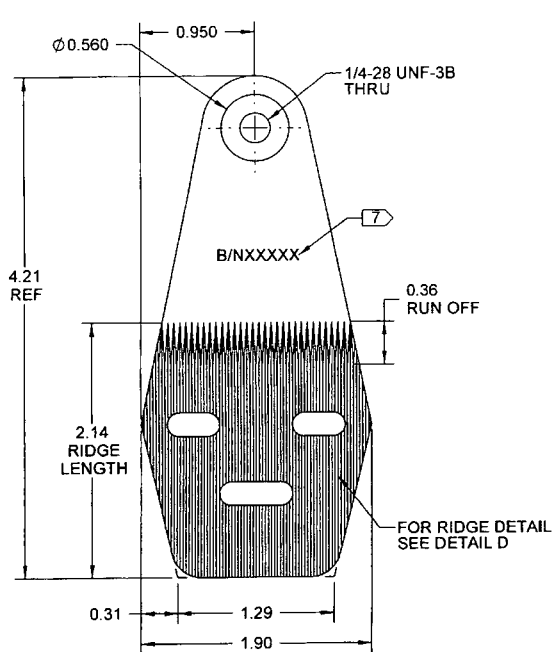


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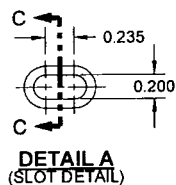
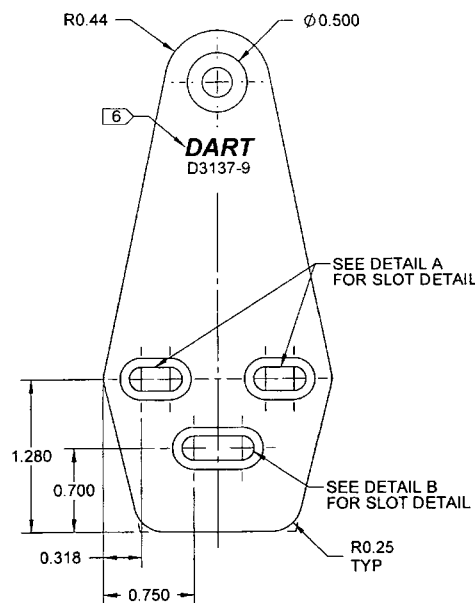
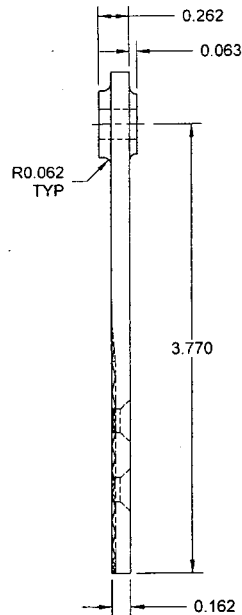
- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.25 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-106

RELEASED
04-06-76

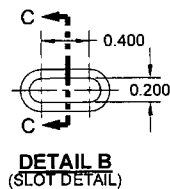
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFC. APPR.		D3137	SHEET 3 OF 5
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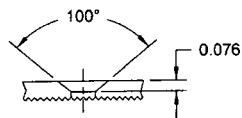
D3137-9 BRACKET



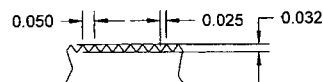
**DETAIL A
(SLOT DETAIL)**



**DETAIL B
(SLOT DETAIL)**



**SECTION C-C
(SLOT DETAIL)**



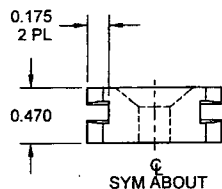
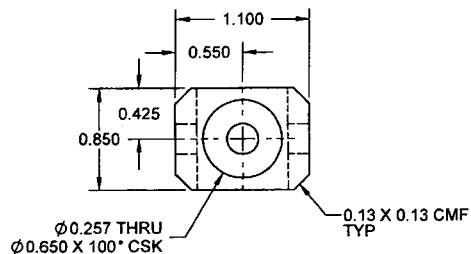
**DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)**

NOTES:

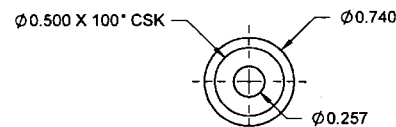
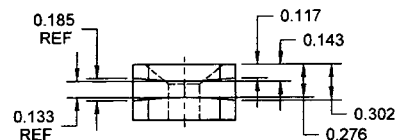
- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 4 OF 5
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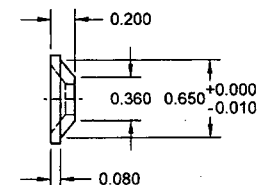
RELEASED
08 06 26 11P



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED
180701-1

DESIGN	DS	DART AEROSPACE LTD	
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MFG. APPR.		D3137	SHEET 5 OF 5
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